

Work Order ID 109667

November-25-13 10:14:20 AM

\*109667\*

Page 1

Item ID: D4095-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate Assembly  
 Start Date: 11/25/13 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 12/09/13 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: MCS Date: 13-11-25 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00				10	0		Jm 13-11-25
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-1) Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		Jm 13-11-25
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				10			
*120*									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89

B 11/26

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 Required Date: 12/09/13 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00  0.00			DAS 30 9-89	10			13/11/26
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O  Memo Ensure joggle as per dwg D4095	0.00  0.00				10			Smf Blind
150 <b>*150*</b> Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M127456</u> Large Fab  Memo	0.00  0.00				10			13-12-06 MAL

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Page 3

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER  
DWG  
A/R ROCKGUARD BATCH: 125335

10     $\emptyset$      $\emptyset$      $\frac{A\theta}{13-12-b}$

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 Required Date: 12/09/13 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
<b>*190*</b>						10			DAS 05 13-12-11
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FR-007</u>	0.00							
<b>*200*</b>						X10	d	ll	13/12/11
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									DJ/R 13-12-11
QC	Memo	0.00							
Quality Control									

13-12-11



# Picklist Print

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Page 1

Work Order ID: 109667

\*109667\*

Parent Item: D4095-041

\*D4095-041\*

Parent Item Name: Wearplate Assembly

Start Date: 11/25/13

Required Date: 12/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	352.2540	2.275	24			
**													
*M304S16GA*													
304/316 Sheet .063													

Im 3-11-25

Location

Loc Qty

Loc Code

MAT020

352.2539998

123136

140.2

M126159

26.22

M126915

185.834

126915

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 109667
<b>Description:</b> Wearplate		<b>Part Number:</b> D4095-1
<b>Inspection Dwg:</b> D4095 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

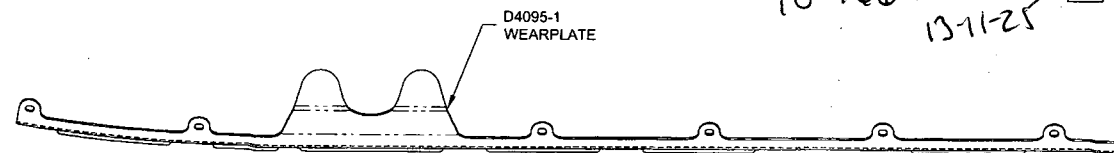
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	—		✓	Jkmon
0.300	+/-0.010	0.302"	—		✓	
0.300	+/-0.010	0.303"	—		✓	
2.432	+/-0.010	2.437"	—		✓	
3.227	+/-0.010	3.230"	—		✓	
4.06	+/-0.030	4.065"	—		✓	
4.98	+/-0.030	4.98"	—		✓	
8.43	+/-0.030	8.43"	—		✓	Producers
9.22	+/-0.030	9.22"	—		✓	
3.500	+/-0.010	3.500"	—		✓	
24.750	+/-0.010	24.750"	—		✓	Jkmo6
11.50	+/-0.030	11.50"	—		✓	
11.472	+/-0.010	11.472"	—		✓	
6.000	+/-0.010	6.004"	—		✓	
12.104	+/-0.010	12.104"	—		✓	
18.000	+/-0.010	18.000"	—		✓	
30.000	+/-0.010	30.000"	—		✓	
9.00	+/-0.030	9.006"	—		✓	
36.000	+/-0.010	36.000"	—		✓	
38.87	+/-0.030	38.87"	—		✓	
2.50	+/-0.030	2.50"	—		✓	
0.063	+/-0.010	0.059"	—		✓	

<b>Measured by:</b> Jm		<b>Audited by:</b> DAS 27		<b>Preliminary Approval:</b>	
<b>Date:</b> 13-11-25		<b>Date:</b> 13/11/26		<b>Date:</b>	

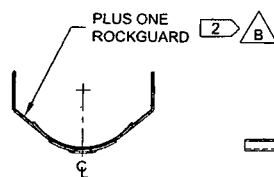
Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

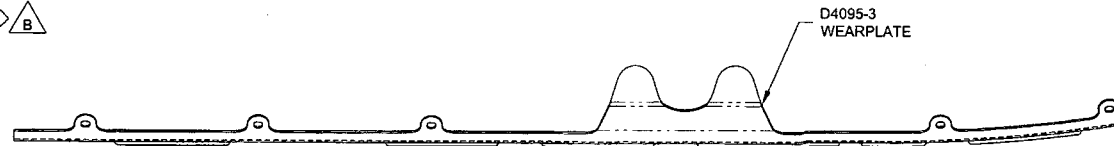
109667 MLC  
131-25



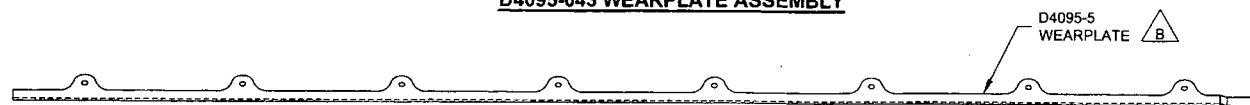
**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**



**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

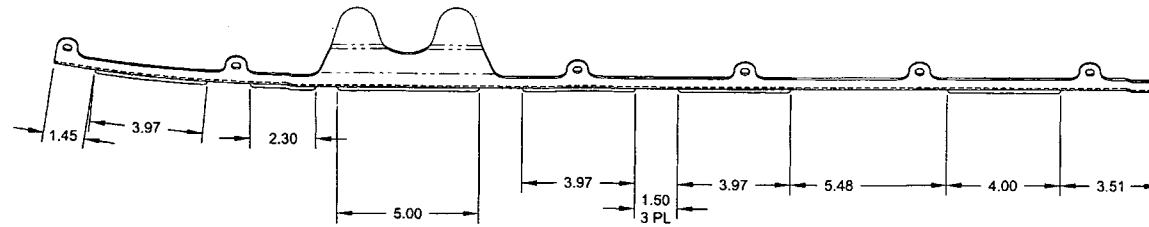
B	REVISED D4095-1-1F/3/3F; 4715 PLUS ONE ROCK-GUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	<i>MB</i>	DRAWING NO.	REV. I
MFG. APPR.	<i>MB</i>	D4095	SHEET 1 OF 8
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	WEARPLATE	NT
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



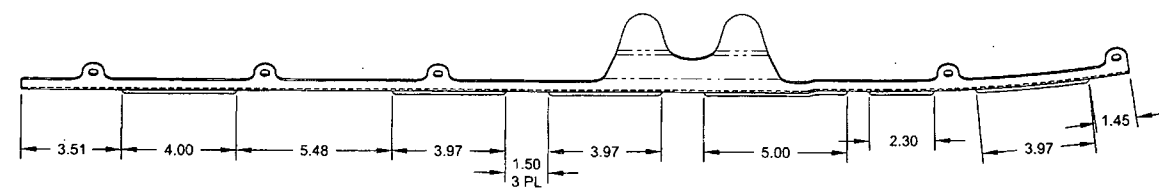


9) PARTS ARE SYMMETRIC ABOUT  $\phi$

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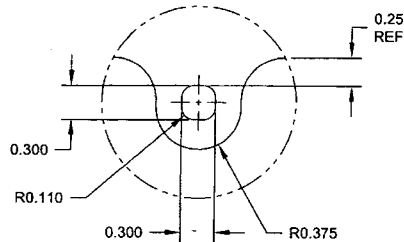
**D4095-1 WELDING DETAIL** B



**D4095-3 WELDING DETAIL** B

RELEASED  
2011-10-31  
MR

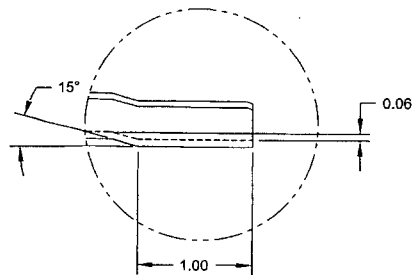
DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 5 OF 8
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DE APPR.	AP	WEARPLATE	NTS
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**DETAIL A: TAB DETAIL**

SCALE 4X

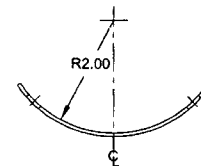
C3-3  
C6-4  
D3-6  
D2-7



**DETAIL B: JOGGLE DETAIL**

SCALE 4X

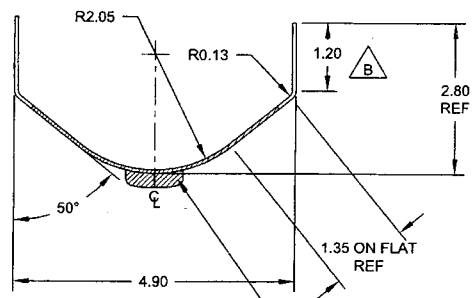
B2-3  
B6-3  
S3-4  
B2-6



**SECTION E-E**

SCALE 2X

B5-6  
B2-7



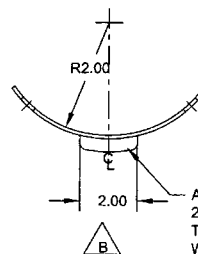
**SECTION C-C**

SCALE 2X

B5-3  
B4-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

B

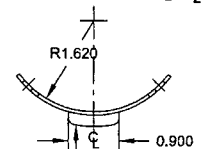


**SECTION D-D**

SCALE 2X

B4-3  
B5-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION F-F**

SCALE 2X

B5-7  
B7-7

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

RELEASED  
2011-10-31  
MP

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
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DE APPR.	AP	WEARPLATE	NTS
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